

# Work Order ID 62239

Wednesday, September 22, 2010 3:36:58 PM



Page 1

Item ID: D3791-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 9/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date: *10-9-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3791

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

*364 . 063*

1-Cut as per Dwg D3791

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*B 10-9-29*

*(12)*

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*B 10-9-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Item Name: Wearplate

Start Date: 9/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Weld hardcoat as per dwg D3791 QSI004								
	Hardcoat 2059b Batch: <u>115850</u>								
160 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

6/10.10.06

8/10/10/07

7/12

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 9/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/07

MF  
10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 22, 2010 3:37:02 PM

Page 1

Work Order ID: 62239

Parent Item: D3791-1

Parent Item Name: Wearplate



Start Date: 9/22/2010

Required Date: 9/22/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	160.8400	0.2917	3.684632			
304/316 Sheet .063													

13 10-9-09

Location

Loc Qty

Loc Code

MAT

146.7

111323

0

115688

146.7

MAT20

14.14

115440

14.14

115688

12

W/O:		WORK ORDER CHANGES					
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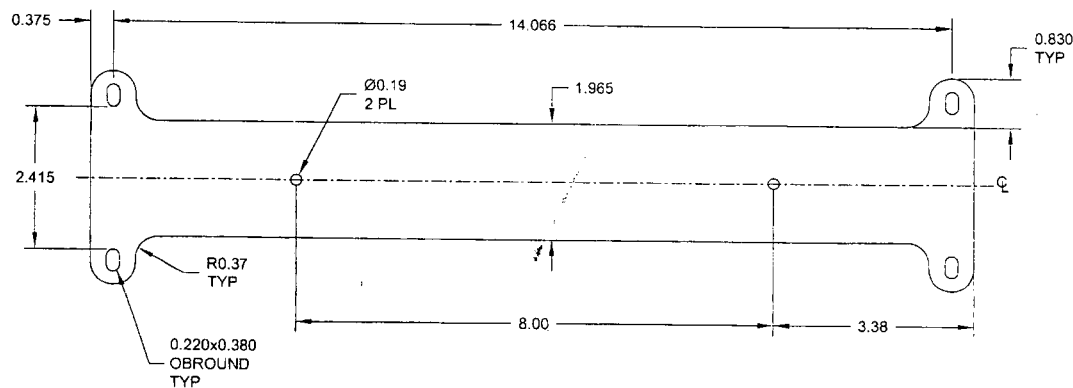
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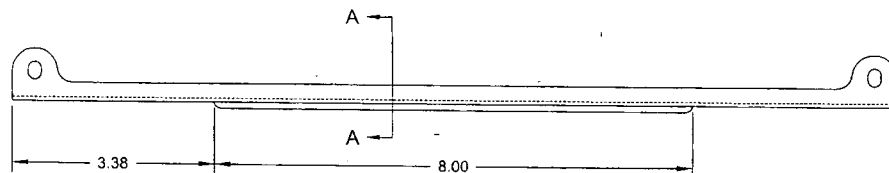
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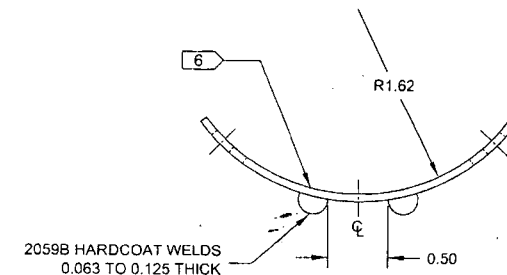
**NOTE:** Date & initial all entries



**D3791-1F FLAT PATTERN**



**D3791-1 WEARPLATE**  
(MAKE FROM D3791-1F)



**SECTION A-A**  
SCALE 2X

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *62239*  
*B/10-923*

**RELEASED**  
*08-05-21/18*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	08.05.13
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3791	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

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